

**BEECHCRAFT
DUKE 60 SERIES
MAINTENANCE MANUAL**

CHAPTER 91

LIST OF PAGE EFFECTIVITY

| CHAPTER SECTION SUBJECT | PAGE | DATE |
|--|-------------|-------------|
| 91-EFFECTIVITY | 1 | Nov 30/83 |
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**CHART 201
TABLE OF TORQUES**

ENGINE MOUNTING

| | |
|---|---------------------|
| Engine Mount Bracket Bolts And Nuts (At Firewall) | 350 to 390 in. lbs. |
| Engine Shock Mount Bolts And Nuts | 250 to 300 in. lbs. |
| Engine Mounting Bracket Bolts | 270 in. lbs. |

ENGINE COMPONENTS

| | |
|---|---------------------|
| Air Conditioner Compressor Mounting Nuts | 160 to 190 in. lbs. |
| Generator Mounting Bracket Bolts (Side Bracket) | 150 in. lbs. |
| (Bottom) | 75 in. lbs. |
| Engine Spark Plugs | 360 to 420 in. lbs. |
| Engine Spark Plug Lead Connections | 25 in. lbs. |
| Engine Oil Filter Retainer Bolt | 25 to 30 ft. lbs. |
| Propeller Starter Gear/Slip Ring to Crankshaft | 60 to 70 in. lbs. |
| Turbocharger Exhaust Clamp P/N MVT-68637-450-M | 50 to 60 in. lbs. |

HORIZONTAL AND VERTICAL STABILIZER

| | |
|---------------------|---------------------|
| All 5/16 - 24 bolts | 100 to 140 in. lbs. |
| All 3/8 - 24 bolts | 160 to 190 in. lbs. |

WING MOUNTING

NOTE

Wing mounting bolt torque should be checked at the first 100 hour inspection and 100 hours after wing reinstallation, replacing a wing bolt(s) or adjusting the wing. If it is necessary to retorque the wing bolts at this time, the bolts should then be checked at the next 100 hour inspection. This check should continue at each 100 hour inspection until it is no longer necessary to retorque the bolts. Check bolt torque at the nut end only.

| | |
|---|--------------------|
| Leading Edge Wing Mounting Bolt (Dry Torque Only) | 100 to 140 in.-lbs |
| Upper Front Wing Mounting Bolt ((Wet Torque Only) | 2480/2600 in.-lbs |
| Upper Rear Wing Mounting Bolt (Wet Torque Only) | 1180/1300 in.-lbs |
| Lower Rear Wing Mounting Bolt (Wet Torque Only) | 2480/2600 in.-lbs |
| Lower Forward Wing Mounting Bolt (See Chapter 57-00-00 for Torquing Instructions) | |

LANDING GEAR

| | |
|----------------------------|---------------------|
| Strut Connecting Arm Bolts | 290 to 410 in. lbs. |
| Horizontal Brace Bolts | 25 to 40 in. lbs. |
| Main Gear Axle Nut | 15 to 20 ft. lbs. |
| Main Gear Hinge Bolts | 250 to 800 in. lbs. |

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CHART 201 (Cont'd)

TABLE OF TORQUES

FUEL SYSTEM (Attaching Bolts For)

| | |
|-------------------------------------|-------------------|
| Filler Necks | 45 to 55 in. lbs. |
| Nacelle Transmitter | 45 to 55 in. lbs. |
| Leading Edge Fuel Cell Outlet Plate | 20 to 30 in. lbs. |
| Transmitter | 25 ± 5 in. lbs. |
| Fuel Boost Pump | 45 to 55 in. lbs. |
| Access Plates | 45 to 55 in. lbs. |
| Fuel Cell Interconnect Clamps | 25 ± 5 in. lbs. |
| Rubber Fuel Nipple Clamps | 25 ± 5 in. lbs. |

HEATER SYSTEM

| | |
|------------------------------|-------------|
| Spark Plug | 28 ft. lbs. |
| Spark Plug High Voltage Lead | 20 ft. lbs. |
| Fuel Spray Nozzle | 20 ft. lbs. |

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CHART 202

TORQUING FINE THREAD SERIES BOLTS LOADED IN SHEAR

NOTE

The following torque values may be used as a guide when specific torques are not called out within this manual.

| SIZE | <i>TORQUE LIMITS RECOMMENDED (INCH-POUNDS)</i> | | <i>MAXIMUM ALLOWABLE TORQUE (INCH-POUNDS)</i> | |
|--------------|--|-------------------------------------|---|-------------------------------------|
| | AN365 AND AN310 NUTS COLUMN 1 | AN364 AND AN320 NUTS COLUMN 2 | AN365 AND AN310 NUTS COLUMN 3 | AN364 AND AN320 NUTS COLUMN 4 |
| 8-36 | 12-15 | 7-9 | 20 | 12 |
| 10-32 | 10-25 | 12-15 | 40 | 25 |
| 1/4 - 28 | 50-70 | 30-40 | 100 | 60 |
| 5/16 - 24 | 100-140 | 60-85 | 225 | 140 |
| 3/8 - 24 | 160-190 | 95-113 | 390 | 240 |
| 7/16 - 20 | 450-500 | 270-300 | 840 | 500 |
| 1/2 - 20 | 480-690 | 290-410 | 1100 | 660 |
| 9/16 - 18 | 800-1000 | 480-600 | 1600 | 960 |
| 5/8 - 18 | 1100-1300 | 660-780 | 2400 | 1400 |
| 3/4 - 16 | 2300-2500 | 1300-1500 | 5000 | 3000 |
| 7/8 - 14 | 2500-3000 | 1500-1800 | 7000 | 4200 |
| 1 - 14 | 3700-5500 | 2200-3300 | 10000 | 6000 |
| 1 - 1/8 - 12 | 5000-7000 | 3000-4200 | 15000 | 9000 |
| 1 - 1/4 - 12 | 9000-11000 | 5400-6600 | 25000 | 15000 |

NOTE

The above values apply to Class 3 threads, cadmium plated and non-lubricated.

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CHART 203

TORQUING COARSE THREAD SERIES BOLTS LOADED IN SHEAR

| SIZE | <i>TORQUE LIMITS RECOMMENDED (INCH-POUNDS)</i> | | <i>MAXIMUM ALLOWABLE TORQUE (INCH-POUNDS)</i> | |
|-------------|--|-------------------------------------|---|-------------------------------------|
| | AN365 AND AN310 NUTS COLUMN 1 | AN364 AND AN320 NUTS COLUMN 2 | AN365 AND AN310 NUTS COLUMN 3 | AN364 AND AN320 NUTS COLUMN 4 |
| 8-32 | 12-15 | 7-9 | 20 | 12 |
| 10-24 | 20-25 | 12-15 | 35 | 21 |
| 1/4 - 20 | 40-50 | 25-30 | 75 | 45 |
| 5/16 - 18 | 80-90 | 48-55 | 160 | 100 |
| 3/8 - 16 | 160-185 | 95-110 | 275 | 170 |
| 7/16 - 14 | 235-255 | 140-155 | 475 | 280 |
| 1/2 - 13 | 400-480 | 240-290 | 880 | 520 |
| 9/16 - 12 | 500-700 | 300-420 | 1100 | 650 |
| 5/8 - 11 | 700-900 | 420-540 | 1500 | 900 |
| 3/4 - 10 | 1150-1600 | 700-950 | 2500 | 1500 |
| 7/8 - 9 | 2200-3000 | 1300-1800 | 4600 | 2700 |
| 1 - 8 | 3700-5000 | 2200-3000 | 7600 | 4500 |
| 1 - 1/8 - 8 | 5500-6500 | 3300-4000 | 12000 | 7200 |
| 1 - 1/4 - 8 | 6500-8000 | 4000-5000 | 16000 | 10000 |

NOTE

The above values apply to Class 3 threads, cadmium plated and non-lubricated.

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CHART 204

FLARE FITTING TORQUE CHART

TORQUE – INCH-POUND

| TUBING OD INCHES | ALUMINUM - ALLOY AND TUBING FLARE 10061 OR AND 10078 | | STEEL TUBING FLARE AND 10061 | | HOSE END FITTING AND HOSE ASSEMBLIES | |
|------------------------|--|---------|------------------------------------|---------|--|---------|
| | MINIMUM | MAXIMUM | MINIMUM | MAXIMUM | MINIMUM | MAXIMUM |
| 1/8 | --- | --- | --- | --- | --- | --- |
| 3/16 | --- | --- | 90 | 100 | 70 | 100 |
| 1/4 | 40 | 65 | 135 | 150 | 70 | 120 |
| 5/16 | 60 | 80 | 180 | 200 | 85 | 180 |
| 3/8 | 75 | 125 | 270 | 300 | 100 | 250 |
| 1/2 | 150 | 250 | 450 | 500 | 210 | 420 |
| 5/8 | 200 | 350 | 650 | 700 | 300 | 480 |
| 3/4 | 300 | 500 | 900 | 1000 | 500 | 850 |
| 1 | 500 | 700 | 1200 | 1400 | 700 | 1150 |
| 1-1/4 | 600 | 900 | --- | --- | --- | --- |
| 1-1/2 | 600 | 900 | --- | --- | --- | --- |
| 1-3/4 | --- | --- | --- | --- | --- | --- |
| 2 | --- | --- | --- | --- | --- | --- |

INSTALLATION OF FLARED FITTINGS

When installing flare fittings, make sure the male threads are properly lubricated in accordance with Chart 208. Torque the fittings in accordance with Chart 204 above. Do not overtorque.

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CHART 205

SEALING MATERIALS

SEALING

Because the BEECHCRAFT Duke is a pressurized aircraft, sealing the skin and bulkhead seams, the windows, doors, etc., is of prime importance. Control cables and torque shafts have removable rubber seals. When making a

structural repair or modification which creates a break in the pressure vessel, the mating surfaces must be sealed with the proper sealer. All other components piercing the pressure vessel or attached to it must be sealed with the sealers described in Chart 205. To assure effective bonding of the sealers, be sure to clean all mating surfaces, mating parts and rubber seals thoroughly.

| <i>ITEM</i> | <i>PRODUCT</i> | <i>VENDOR</i> |
|-------------|--------------------------|---|
| 1. | A56B Cement | B. F. Goodrich Co., Akron, Ohio |
| 2. | EC-2141 | Minnesota Mining and Manufacturing Co., St. Paul, Minnesota |
| 3. | Permatex Sealer No. 2 | Permatex Co., Inc., Kansas City, Kansas |
| 4. | Presstite Sealer No. 155 | Presstite Engineering Co., St. Louis, Missouri |
| 5. | EP-711 Sealer | Coast Pro Seal and Mfg. Co., Los Angeles, California |
| 6. | EC-1792 | Minnesota Mining and Manufacturing Co., St. Paul, Minnesota |
| 7. | EC-1239 Sealer | Minnesota Mining and Manufacturing Co., St. Paul, Minnesota |
| 8. | Y-9136 Teflon Tape | Minnesota Mining and Manufacturing Co., St. Paul, Minnesota |
| 9. | PR-1221 Sealer | Minnesota Mining and Manufacturing Co., St. Paul, Minnesota |
| 10. | EC-750 | Minnesota Mining and Manufacturing Co., St. Paul, Minnesota |
| 11. | EC-801 | Minnesota Mining and Manufacturing Co., St. Paul, Minnesota |
| 12. | EC-1300L | Minnesota Mining and Manufacturing Co., St. Paul, Minnesota |
| 13. | EC-612 | Minnesota Mining and Manufacturing Co., St. Paul, Minnesota |
| 14. | EC-776 | Minnesota Mining and Manufacturing Co., St. Paul, Minnesota |
| 15. | EC-801A-1/2 | Minnesota Mining and Manufacturing Co., St. Paul, Minnesota |
| 16. | EC-1368 | Minnesota Mining and Manufacturing Co., St. Paul, Minnesota |

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Chart 205 (Cont'd)

SEALING MATERIALS

| <i>ITEM</i> | <i>PRODUCT</i> | <i>VENDOR</i> |
|-------------|--------------------|--|
| 17. | EC-1403 | Minnesota Mining and Manufacturing Co., St. Paul, Minnesota |
| 18. | Bostic 1008 | United Shoe Machinery Corp., B. B. Division, 748 Memorial Drive, Cambridge, Massachusetts |
| 19. | Pro Seal 890 B-1/2 | Coast Pro-Seal and Manufacturing Co., Los Angeles, California |
| 20. | EC-1675 B-1/2 | Minnesota Mining and Manufacturing Co., St. Paul, Minnesota |

NOTE

Proper procedure for applying the sealers may be found in the directions on the sealer container and/or in the chapter of this manual applying to that area being worked.

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CHART 206

APPLICATION OF SEALING MATERIALS

| <i>APPLICATION</i> | <i>MATERIAL</i> | <i>REMARKS</i> |
|---------------------------------------|--|---|
| Metal Surfaces and Wet Wing Tip | O-A-51, Acetone; MIL-M-13999, Methyl Ethyl Ketone; *TT-N-95, Naphtha | Clean all surfaces prior to application of adhesive or sealer. Adhesives or sealers may be applied to zinc chromate primed surfaces. |
| Synthetic or Natural Rubber | MIL-M-13999, Methyl Ethyl Ketone; TT-T-548, Toluol | Clean all surfaces to be bonded. Where possible, scuff surface by wire brushing or sanding. |
| Silicone Rubber | TT-X-916, Zylene | Clean all surfaces with zylene only when a surface lubricant, i.e. soapstone has been applied by the manufacturer. |
| Rubber Door Seals | EC-847 | Rubber seals are installed to prevent air leakage. The seals must be cut with mitered corners to fit the periphery of the door jam. Apply a thin coating of adhesive to both the areas where the seal will be placed and the side of the seal to be bonded. Allow to dry completely, then lightly wipe the surface to be bonded with a cloth dampened with MIL-M-13999 methyl ethyl ketone to reactivate the adhesive. Position the seal carefully as it has immediate adhesion when laid in place. |
| Unused Drill Holes | EC-1239, *PR-890 B-1/2 or *EC-1675 B-1/2 | Plug holes which go through pressure boundaries with rivets, or seal with EC-1239. |
| Plumbing Fittings | EC-1239 B-1/2 or PR-1221 B8 | Apply to all plumbing fittings which pass through a pressure boundary. |
| Electrical Fittings | EC-1239, EC-776 | Seal all electrical plugs which pass through a pressure boundary with EC-1239. Apply EC-776 on the screw head used for attachments upon completion of the installation. |

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CHART 206 (Cont'd)

APPLICATION OF SEALING MATERIALS

| <i>APPLICATION</i> | <i>MATERIAL</i> | <i>REMARKS</i> |
|---------------------|--|--|
| Faying Surface Seal | PR-1221 B8, EC-1239 B-1/2 EC-1792 *PR-890 B-1/2 *EC-1675 B-1/2 | Apply with a bead approximately 1/8 to 3/16 inch in height, depending on the width of the lapped skin or angles. Apply sufficient sealant so there will be a slight squeeze out of sealant along the edge on the pressure side of the assembly when the assembly is completed. |
| Fillet Seal | PR-1221 B8, EC-1239 B-1/2 *PR-890 B-1/2 *EC-1675 B-1/2 | Apply with a gun capable of extruding beads at least three times the thickness of the skin being sealed. Work the tip of the gun so it packs the sealant into the cracks, crevices or skin lap. The fillet must make complete contact with the immediate area. |
| Gap Seal | EC-1239 *PR-890 B-1/2 *EC-1675 B-1/2 | Apply with a gun or spatula over the edges of the flanges forming at least 1/4 inch lap with a center thickness of 1/4 to 1/2 inch, depending on the size of the hole. Gaps and voids larger than 3/8 inch in two dimensions should be sealed with a mechanical closure. |
| Coating Seal | EC-776 *PR-890 B-1/2 *EC-1675 B-1/2 | Apply as necessary to prevent pressure leaks on an area double the size of the rivet butt, working the sealer with the brush to insure that the rivet is completely covered. |
| Window Seal | EC-1202 | Apply around periphery of all window panels prior to installation in frames. Tape width is to extend equally on both sides of panels. |
| Sealant Ribbon | Prestite 155 | Apply around periphery of all removable inspection doors and panels. |
| *Wet Wing Tip | | |

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CHART 206 (Cont'd)

APPLICATION OF SEALING MATERIALS

TERMS

Faying Surface Seal refers to a seal where the sealing material is applied between the joint surfaces before assembly.

Fillet Seal refers to a seal over a joint or seam that fills the gap. It is not to be applied in the nature of a bridge.

Gap Seal refers to a seal where the sealing material is packed into a gap or void and lapped over the edges. These seals should not be used on gaps or voids larger than 3/8 inch in two dimensions.

Pot Life refers to the workable life of a two-part sealant mixture.

Sealing Ribbon refers to an extruded section ribbon sealer used on removable inspection doors.

Sealing Tape refers to a sealer made in the form of a tape and supported by a loose woven tobacco cloth. This tape is used in areas where a wide flat layer of sealer is required, such as a window installation.

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CHART 207

CONSUMABLE MATERIALS

Only the basic number of each Military Specification is included in the Consumable Materials Chart. No attempt has been made to update the basic number with the letter suffix that designates the current issues of the various specifications.

Vendors that are listed as meeting the Federal and Military Specifications are provided as reference only and are not specifically recommended by Beech Aircraft Corporation; consequently, any product conforming to the specification listed may be used. The products listed below have been tested and approved for aviation usage by Beech Aircraft Corporation, the vendor, or by compliance with the applicable specifications. Other products that are locally procurable which conform to the requirements of the applicable Military Specification may be used even though not specifically included herein.

It is the responsibility of the operator/user to determine the current revision of the applicable Military Specification prior to usage of that item. This determination may be made by contacting the vendor of a specific item.

| <i>ITEM</i> | <i>MATERIAL</i> | <i>SPECIFICATIONS</i> | <i>VENDOR PRODUCTS</i> |
|-------------|-------------------------------------|--|---|
| 1. | Fuel, Engine | 100/130 octane (If not available, use 115/145) Never use 91/96 octane fuel. | |
| 2. | Oil, Engine (Ashless Dispersant) | MIL-L-22851 | Global Concentrate A Delta Petroleum Company Inc., P. O. Box 10397 New Orleans, La. 70121 Paranox 160 and 165 Enjay Chemical Company 60 West 49th Street New York, N. Y. 10020 RT-451, RM-173E, RM-180E Mobil Oil Corporation 150 East 42nd Street New York, N. Y. 10017 Shell Concentrate A Code 60068, Aeroshell W120, Aeroshell W80 Shell Oil Company One Shell Plaza Houston, Texas 77002 TX-6309 Aircraft Engine Oil, Premium AD120, Premium AD80 Texaco Inc. 135 East 42nd Street New York, N. Y. 10017 PQ Aviation Lubricant 753 American Oil and Supply Co. 238 Wilson Avenue Newark, N. J. 07105 |

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**CHART 207 (Cont'd)
CONSUMABLE MATERIALS**

| ITEM | MATERIAL | SPECIFICATIONS | VENDOR PRODUCTS |
|------|---|----------------|---|
| 2. | Oil, Engine (Ashless Dispersant) (Cont'd) | MIL-L-22851 | <p>Chevron Aero Oil Grade 120 Chevron Oil Co. 1200 State Street Perth Amboy, N. J. 08861</p> <p>Esso Aviation Oil E-120, Enco Aviation Oil E-120, Esso Aviation Oil A-100, Enco Aviation Oil A-100, Esso Aviation Oil E-80, Enco Aviation Oil E-80</p> <p>Enco Aviation Oil E-80 Exxon Company, U.S.A. P. O. Box 2180 Houston, Texas 77001</p> <p>Chevron Aero Oil Grade 120 Standard Oil Co. of Calif. 225 Bush Street San Francisco, Calif. 94120</p> |
| 3. | Corrosion Preventive Compound | MIL-C-6529 | <p>Anti-Corrode No. 205 Cities Service Oil Co. 60 Wall Tower, New York 5, N. Y.</p> <p>Rust Foil No. 652-2, Franklin Oil and Gas Co., Bedford, Ohio</p> <p>Kendex No. 7038, Kendall Refining Co., Bradford, Pa.</p> |
| 4. | Lubricating Oil | MIL-L-6081 | <p>Gulflite Turbojet Oil No. 1010, Gulf Oil Corp. Pittsburgh, Pa.</p> <p>Aeroshell No. 3-1286, Shell Oil Co., 50 West 50th Street, New York, N. Y. 10020</p> <p>Jet Engine Oil No. 1010, Texaco Inc., 135 East 42nd Street, New York N. Y. 10017</p> |

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**CHART 207 (Cont'd)
CONSUMABLE MATERIALS**

| ITEM | MATERIAL | SPECIFICATIONS | VENDOR PRODUCTS |
|------|---|---|--|
| 5. | Lubricating Oil | SAE 20 or SAE 10W30 | |
| 6. | Lubricating Oil, Aircraft Reciprocating (Piston) Engine | MIL-L-6082 | <p>Conoco Aero Oil No. 1065, Continental Oil Co. Ponca City, Oklahoma</p> <p>Phillips 66 Aviation Engine Oil, Grade 1065 Phillips Petroleum Co. Bartlesville, Oklahoma</p> <p>Skefflite No. 100, Skelly Oil Co., El Dorado, Kansas</p> <p>Avrey 10V1100, Socony Mobil Oil Co. Inc., 150 East 42nd Street, New York, N. Y. 10017</p> <p>Or any approved air- plane engine oil (graded at 1065 or 1100).</p> |
| 7. | Lubricating Oil (Gear) | MIL-L-6086 Grade M | <p>Trojan Gear Oil No. 6086 M. Cities Service Oil Co., 60 Wall Tower, New York 5, N. Y.</p> <p>Aeroshell Fluid 5 M, Shell Oil Co., 50 West 50th Street, New York, N. Y.</p> <p>L-1195, Sinclair Re- fining Co., 600 Fifth Avenue, New York, N. Y.</p> |
| 8. | Lubricating Grease (General Purpose) | MIL-G-7711 (Superseded by MIL-G-81322, See Item 9) | |

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**CHART 207 (Cont'd)
CONSUMABLE MATERIALS**

| ITEM | MATERIAL | SPECIFICATIONS | VENDOR PRODUCTS |
|------|---|-----------------------|---|
| 9. | Lubricating Grease | MIL-G-81322 | Mobilgrease 28 Mobil Oil Corporation Shoreham Building Washington D.C. 20005 |
| | NOTE MIL-G-81322 is not compatible with Aeroshell No. 5 and contains chemicals harmful to painted surfaces. | | Aeroshell 22, Shell Oil Co., 50 West 50th Street, New York, N. Y. |
| 10. | Lubricating Grease (Gear) | Mobile Compound G. G. | |
| 11. | Lubricating Grease (Aircraft and Instruments, Low and High Temperature) | MIL-G-23827 | Supermil Grease No. A72832, American Oil Co., 910 South Michigan Avenue Chicago, Ill. 60680 |
| | NOTE Precautions should be taken when using MIL-G-23827 and MIL-G-81322, since these greases contain chemi- cals harmful to painted surfaces. | | Royco 27A, Royal Lubricants Co., River Road, P. O. Box 95, Hanover, N. J. 07936 |
| | | | Shell 6249 Grease, Shell Oil Co., 50 West 50th St., New York 20, N. Y. |
| 12. | Lubricant, Molybdenum Disulfide Powder | MIL-M-7866 | Molykote Z Wilco Co., Wichita, Kansas |
| | | | Molykote Z Standard Oil of Kentucky |
| | | | Molykote Z, Haskell Engineering and Supply Company, 100 East Graham Place Burbank, California 91502 |
| | | | Moly-Paul No. 4, K. S. Paul Products Ltd. Nobel Road, London, England |

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**CHART 202 (Cont'd)
CONSUMABLE MATERIALS**

| ITEM | MATERIAL | SPECIFICATIONS | VENDOR PRODUCTS |
|------|---|---------------------------------------|---|
| 13. | Hydraulic Fluid | MIL-H-5606 | Brayco 756D, Bray Oil Co., 3344 Medford Street, Los Angeles 63, California PED 3656 Standard Oil Co. of California 225 Bush Street, San Francisco 20, California |
| 14. | Oxygen-System Leak Testing Compound | MIL-L-25567 | |
| 15. | Solvent, Dry Cleaning or White Spirit | PD680 or British Specification 245 | |
| 16. | Lubricating Oil | SAE-10 | |
| 17. | Air conditioner Refrigerant | R-12 | |
| 18. | Oil (Air Conditioner Compressor) 500 Viscosity | | Suniso No. 5 Virginia Chemical and Smelting Co., West Norfolk, Virginia Texaco Capella E, Texaco Inc., 135 East 42nd Street, New York, N. Y. 10017 |
| 19. | Aviator's Breathing Oxygen | MIL-O-27210 | |
| 20. | Naphtha | TT-N-95 | |
| 21. | Methyl Ethyl Ketone | MIL-M-13999 | |
| 22. | Toluol (Toluene) | TT-T-548 | |
| 23. | Paint Remover | | Turco No. 4260 Turco Products Inc., Los Angeles, California |
| 24. | Epoxy Primer | | Ameron Industrial Coatings Division P.O. Box 2153, Wichita, Kansas |

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**CHART 207 (Cont'd)
CONSUMABLE MATERIALS**

| ITEM | MATERIAL | SPECIFICATIONS | VENDOR PRODUCTS |
|------|---|-------------------------------------|--|
| 25. | Wash Primer | | Ameron Industrial Coatings Division P.O. Box 2153, Wichita, Kansas |
| 26. | Zinc Chromate Primer | MIL-P-8585 | |
| 27. | Rubber Hose | MIL-H-5593 | |
| 28. | Oil, Engine Preservative | MIL-L-21260 | |
| 29. | Graphite, Lubricating | SS-G-659 (Supersedes MIL-G-6711) | Anchor Packing Co., 401 Broad St. Philadelphia, PA. 19108 |
| | NOTE Lubricating Graphite Superseded by Item 12 | | Bel-Ray Co., Inc., P.O. Box 526, Farmingdale, N.J. 07727 |
| | | | Crane Packing Co., 6400 Oakton St., Morton Grove, Ill. 60053 |
| | | | Ducommun Inc., Super-Temp Div., 11120 S. Norwalk Blvd., Santa Fe Springs Ca. 90670 |
| 30. | Lubricating Grease | Enco Andok-B | Humble Oil Co. Houston, Texas |
| 31. | Solvent | | CRC-2-26, Corrosion Reaction Consultants Limeklm Pike, Dresher, Pa. |
| 32. | Laminated Glass Cloth | MIL-F-9084 | Trevano, Coast Manufactur- ing and Supply Inc., Box 71, Livermore, California |
| | | | Uniglass, United Merchants and Manufacturing Inc. 1407 Broadway, New York, New York 10018 |
| 33. | Resin | MIL-R-7575 | Laminac 4116, American Cyanamid Co., Wallingford, Connecticut |
| | | | Glidpol 1001, The Glidden Company, 925 Euclid Ave. Cleveland, Ohio |

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**CONSUMABLE MATERIALS
CHART 207 (Cont'd)**

| ITEM | MATERIAL | SPECIFICATIONS | VENDOR PRODUCTS |
|------|-------------------------|--------------------------|--|
| 34. | Lubricating Grease | Aeroshell 7A | Shell Oil Co., 50 West 50th Street, New York, N. Y. |
| 35. | Urethane Primer | | U. S. Paint Lacquer and Chemical Co., 1501 N. Belmont, P. O. Box 8151, Wichita, Kansas 67208 |
| | | | Ameron Industrial Coatings Division P.O. Box 2153, Wichita, Kansas |
| 36. | Thread Locking Compound | Loctite Sealant, Grade A | Loctite Corp. 705 N. Mountain Road Newington, Conn. 06111 |
| 37. | Penetrating Oil | Mouse Milk | Worldwide Aircraft Filters Corp., 1685 Abram Ct. San Leandro Calif. 94577 |
| | | Kano Kroil | Kano Laboratories Inc. Nashville, Tennessee |
| 38. | Lubricating Grease | Aeroshell Grease 5, | Aeroshell Grease 5, Shell Oil Co., 50 West 50th Street, New York, N. Y. |
| 39. | Cement | EC2262 | Minnesota Mining and Manufacturing Company St. Paul, Minneosta |
| 40. | Primer | Locquic "N" | Loctite Corp. 705 N. Mountain Road Newington, Conn. 06111 |
| 41. | Cleaner | Turco Metal-glo No. 3 | Turco Products, Inc., Los Angeles, Calif. |
| 42. | Paint Stripper | Turco 4260 | Turco Products Inc. Los Angeles, California |

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**CHART 207 (Cont'd)
CONSUMABLE MATERIALS**

| ITEM | MATERIAL | SPECIFICATIONS | VENDOR PRODUCTS |
|------|-------------------------------|---|---|
| 43. | Corrosion Preventive Compound | MIL-C-16173 Grade 2 | Braycote 137, Bray Oil Co. 1925 N. Marianna Avenue Los Angeles, California 90032 Petrotech 1-4 Penreco, P.O. Box 671, Butler, Pa. 16001 |
| 44. | Lubricating Grease | MIL-G-7118 | |
| 45. | Primer, Degreasing | EC3911 | Minnesota Mining and Manufacturing Co., St. Paul, Minnesota |
| 46. | Lubricating Silicone | G-322L | General Electric Waterford, New York 12188 |
| 47. | Anti-Seize Compound | Loctite 76764 Paste Form 1 lb Bursh Top Can | Loctite Corp. 705 N. Mountain Road Newington, Conn. 06111 |
| 48. | Coating | Alodine 1200, 1200S or 1201 | Amchem Products Inc. Spring Garden Street Ambler, Pennsylvania 19002 |

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**CHART 208
THREAD LUBRICANTS**

The vendor products appearing in this chart have been selected at random to help field personnel determine products conforming to the specifications listed in this publication. The brand names are listed for ready reference and are not specifically recommended by Beech Aircraft Corporation. Any product which conforms to the referenced specification may be used.

| <i>SYSTEM</i> | <i>MATERIAL</i> | <i>SPECIFICATION</i> | <i>VENDOR PRODUCTS</i> |
|--------------------------------------|--|---------------------------|--|
| Fuel | Petrolatum | VV-P-236 | |
| Oil, Manifold Pressure, Air Pressure | Lubricating Grease (Gasoline and Oil Resistant) | MIL-G-6032 | L-237, Lehigh Chemical Co. Chestertown, Maryland Rockwell 950, Rockwell Mfg. Pittsburgh 8, Pa. Royco 32, Royal Lubricants Co. Hanover, New Jersey |
| Deicer, Static, Pitot | Anti-Seize, White Lead Base | TT-A-580 | Armite Product Armite Laboratories, Los Angeles, California |
| Autopilot (Pipe Threads Only) | Anti-Seize, White Lead Base | JAN-A-669 | |
| Brakes | Hydraulic Fluid or Anti-Seize, White Lead Base | MIL-H-5606 or TT-A-580 | |
| Air Conditioner | Anti-Seize, Graphite Petrolatum or Anti-Seize, White Lead Base | MIL-T-5544 or TT-A-580 | |
| Oxygen, High Pressure Side | Tape, Tetrafluoroethylene | MIL-T-27730 | Permacel Tape Corp., New Brunswick, New Jersey |
| Turbocharger Inlet Probe | Anti-Seize Compound | MIL-A-907D | Anti-Seize Compound C5A, Fel-Pro Inc. 7450 McCormick Skokie, Illinois |

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CHART 209

APPROVED ENGINE OILS (ASHLESS DISPERSANT)

| <i>SPECIFICATION</i> | <i>PRODUCT</i> | <i>*VENDOR</i> |
|----------------------|--|--|
| MIL-L-22851 | Global Concentrate A | Delta Petroleum Company, Inc. P.O. Box 10397 New Orleans, La. 70121 |
| | Paranox 160 and 165 | Enjay Chemical Company 60 West 49th Street New York, N.Y. 10020 |
| | RT-451, RM-173E, RM-180E | Mobil Oil Corporation 150 East 42nd Street New York, N.Y. 10017 |
| | Shell Concentrate A Code 60068 Aeroshell W120 Aeroshell W80 | Shell Oil Company One Shell Plaza Houston, Texas 77002 |
| | TX-6309 Aircraft Engine Oil Premium AD120 Aircraft Engine Oil Premium AD80 | Texaco Inc. 135 East 42nd Street New York, N.Y. 10017 |
| | PO Aviation Lubricant 753 | American Oil and Supply Co. 238 Wilson Avenue Newark, N.J. 07105 |
| | Chevron Aero Oil Grade 120 | Chevron Oil Co. 1200 State Street Perth Amboy, N.J. 08861 |
| | Esso Aviation Oil E-120 Enco Aviation Oil E-120 Esso Aviation Oil A-100 Enco Aviation Oil A-100 Esso Aviation Oil E-80 Enco Aviation Oil E-80 | Humble Oil and Refining Co. P.O. Box 2180 Houston, Texas |
| | Chevron Aero Oil Grade 120 | Standard Oil Co. of Calif. 225 Bush Street San Francisco, Calif. 94120 |

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"END"